

Work Order ID 69522

Wednesday, May 11, 2011 4:02:55 PM



Page 1

Item ID:	D2565-107	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Strut					
Start Date:	5/11/2011	Start Qty:	12.00		Cust Item ID:	
Required Date:	5/16/2011	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-05-12	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2565	Rev E								

100	Punch ends and deburr as per dwg	0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Punch as per Dwg D2565 using DT 8313								

80 11/05/31

13

110	Small Fab	0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr								

80 11/05/31 13

120	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							

80 11/05/31

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2565-107

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 5/11/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
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Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:45
400 OF
8:15

13x Ø M-11/08/01

140	QC3- Inspect Part Finish	0.00							
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QC

Quality Control

Memo

0.00

13 Ø M-11/06/01

150	Identify as per dwg & Stock Location	0.00							
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Packaging

Packaging

Memo

0.00

11/6/11 5/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Page 3

Item ID: D2565-107

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 5/11/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/2011

ME
11-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, May 11, 2011 4:03:03 PM

Page 1

Work Order ID: 69522

Parent Item: D2565-107

Parent Item Name: Strut





Start Date: 5/11/2011

Required Date: 5/16/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: ☐F☐02.04.16☐Added dwg Rev.C1☐NG☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049 		Purchased	No			100	f	147.0086	1.1191	14.136			
304 RD Tube .750 x .049W													

SA 4/6/5/11

Location

Loc Qty

Loc Code

MAT017

147.00863

109314

9.333

111619

3

112187

4

112800

11

114852

2.75

116108

3

116720

1.833

117030

32.09263

117598

80

4 117792

18





W/O:		WORK ORDER CHANGES					
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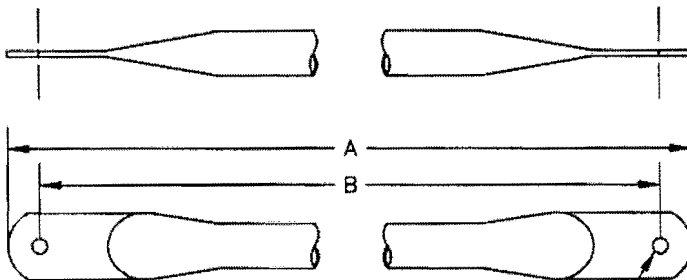
NOTE: Date & initial all entries



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69572



PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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